

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-009076**Date Inspected:** 05-Sep-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Yu Dong Ping.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Amit K. Juvekar, was present during the times noted above for observations relative to the work being performed.

This QA Inspector observed the following work in progress:

Bay11, South Tower, STRUTS.

SMAW welding of weld joint SD1-A6002-10-7B, 11A, 9A; located on Bay11, South Tower. Welder is identified as 041271, 047470; ZPMC Quality Control Inspector (QC) is identified as Yu Dong Ping. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-3212-TC-U5B-1.

Outside Yard(Dock).

East Tower Lift 1, Internal Splice Plates Installed on Skin A, B, &E.

East Tower Lift 2, Preparation for Internal Splice Plate Installation in progress(Rotating Tower).

South Tower Lift 1, Internal Splice Plates Installed on Skin A, B. Also Preparing for Internal Splice Plate Installation on Skin E.

South Tower Lift 2, Drilling Holes on Doubler Plate on Skin E 53M Double Diaphragm.

This QA Inspector carried out NDE on following:

Bay 10, South Tower, Lift 3.

This QA inspector performs Random Visual Testing (VT), Magnetic Particle Testing (MT) of approximately 10% area previously tested and accepted by ZPMC Quality Control personnel, FOR GREEN TAG. This QA

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## WELDING INSPECTION REPORT

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Inspector generated an MT report (TL-6028) for this date. The members are identified as

- 1) SSD1-FASA3-1C/E-16, 1, 2, 3, 4. Doubler Plate.
- 2) SSD1-FASA3-1B/E-1, 2, 3, 4, 25, 5, 6, 7, 8. Doubler Plate.
- 3) SSD1-FASA3-1A/E-5, 6, 21, 22, 23, 24, 25, 26. Small Doubler Plate.

The Quality Assurance Inspector (QA) observed one (1) Aprox.60mm linear indication at weld joint SSD1-FASA3-1A/E-6. ZPMC provided the NDT Notification Sheet # 004148 informing Caltrans QA that they have completed their 10% NDT requirements. The area MT tested by Caltrans QA was outside the 10% tested by ZPMC.

Bay 11, West Tower, Lift 4, Skin E with Stiffeners(CJP Only).

This QA inspector performs Random Ultrasonic Testing (UT) of approximately 10% area previously tested and

accepted by ZPMC Quality Control personnel, FOR GREEN TAG. This QA Inspector generated an UT report (TL-6027) for this date. The members are identified as

- 1) WSD1-FESA4-4F/F-1, 4, 10, 14, 17, 21, 24, 27, 31, 67(A/B).
- 2) WSD1-FESA4-4F/F-32, 35, 41, 45, 48, 52, 55, 58, 64, 68(A/B).

GREEN TAG# 10421.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

### Summary of Conversations:

No relevant conversations.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Serge Sinevod, 13482570045, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Juvekar,Amit	Quality Assurance Inspector
<b>Reviewed By:</b>	Clifford,William	QA Reviewer

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